

Date: Tuesday, 29/04/2008 10:47:07 AM
 User: Linda L. acelle

Process Sheet

OK

| | | | |
|-----------------------|--------------------------------|------------------|------------------------------|
| Customer | : CC-DAR01 Dart Aerospace Ltd. | Drawing Name | : FRONT OUTBOARD LEG, LH |
| Job Number | : 38881 | | |
| Estimate Number | : 10804 | | |
| P.O. Number | : | Part Number | : D37683 |
| This Issue | : 29/04/2008 S.O. No. : | Drawing Number | : PROTOTYPE |
| Prsht Rev. | : NC | Project Number | : |
| First Issue | : / / Type : R & D SM/MED FAB | Drawing Revision | : 08.04.23 |
| Previous Run | : 38876 | Material | : |
| Written By | : | Due Date | : 16/05/2008 Qty: 1 Um: Each |
| Checked & Approved By | : | | |
| Comment | : | | |

Additional Product

PROTOTYPE

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

MAKE PER DRWG D3768 REV A

M 106734

FF 08-05-08 ①

2.0

M6061T6T1000W065

6061T6 TUBE



Comment: Qty.: 0.9000 f(s)/Unit Total : 0.9000 f(s)
 6061T6 TUBE

FF 08-05-08 ①

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL

08/05/08 502/05/08

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

ACID ETCH AND ALODINE PER QSI 005

RD/FL 08/05/12 ①

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 8/5/12 ①

Process Sheet

Customer: -CC-DAR01 Dart Aerospace Ltd.

Drawing Name: FRONT OUTBOARD LEG, LH

Job Number: 38881

Part Number: D37683

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

GIVE TO CHRIS P-ENG

CHARGE TO JOB #00196

FOR ENGINEERING USE ONLY

PU
08.05.29

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.05.29 *Prototype*
A.

Job Completion



U 08.06.11

KAISER CHANDLER

CHANDLER PLANT
BOX 5011 6573 W WILLIS ROAD
CHANDLER AZ 85226
PH: 520.798.1697
FAX: 520.798.0596
SALES: 800.528.8274

CERTIFICATION and PHYSICAL TEST RESULTS

QP 026A

These results are for

MARMON/KEYSTONE CORP

Mill Number

175-48862.

Purchase Order No 60-29318-002

Alloy

6061

Temper..... T6

Part No, Item No, Commodity No or Inventory No

Size Description.

1.00 IN OD X .065 IN WALL

Specification(s).

WW-T-700/6F ASTM B210-04 AMS 4082N

Additional procedures as called for on Specification:

WE TAKE EXCEPTION TO PARA. 5.2.1. Per AMS 4082N, WAS NOT OILED.

| Limits | Chemical Composition | | | Per Aluminum Standards and Data 2003 | | | | | | | | |
|---------|----------------------|------|------|--------------------------------------|------|------|------|------|------|------------|-----------|-----------|
| MIN | 0.40 | 0.15 | 0.8 | 0.04 | 0.25 | 0.15 | 0.05 | 0.05 | 0.05 | 0.05 | 0.05 | Remainder |
| MAX | 0.8 | 0.7 | 0.40 | 0.15 | 1.2 | 0.35 | 0.25 | 0.15 | 0.15 | 0.15 | 0.15 | Remainder |
| Actuals | Si | Fe | Cu | Mn | Mg | Cr | Ni | Zn | Ti | Others | Al | |
| | 0.63 | 0.28 | 0.22 | 0.03 | 0.96 | 0.06 | | 0.03 | 0.01 | | | |
| | | | | | | | | | | Each 0.05 | Remainder | |
| | | | | | | | | | | Total 0.15 | | |

* For WW-T-700/6F specification, maximum Si plus Fe is .45%.

** 1100 Alloy Max Si + Fe is 0.95 %

| Mechanical Properties | | Properties | | |
|-----------------------|------|------------|--------------|--------------|
| Lot # | Temp | Yield PSI | Ultimate PSI | Elongation % |
| 48862 AI T6 | | 42,800 | 48,600 | 15 |
| 48862 BA T6 | | 42,700 | 48,400 | 15 |

Domestic Melt Source Made in USA

We hereby certify that the material covered by this report has been inspected in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description; and that samples representative of the material met the composition limits and had the mechanical properties as indicated.

Date 05/19/2007

Wilfredo A. dela Cruz

Wilfredo A. delaCruz
Sr. Metallurgical Engineer

CertAct

Form 0042

AT 1.065 734

SLSPRS:
OR.REF:

To:

INIT.:

06/05/2007 From: MARMON/KEYSTONE

M/K OR:
C.P.O.:BN4984
C PART:

8

7

6

5

D

C

B

A



2

D3768-1 FRONT INBOARD LEG**D3768-3 FRC****NOTES:**

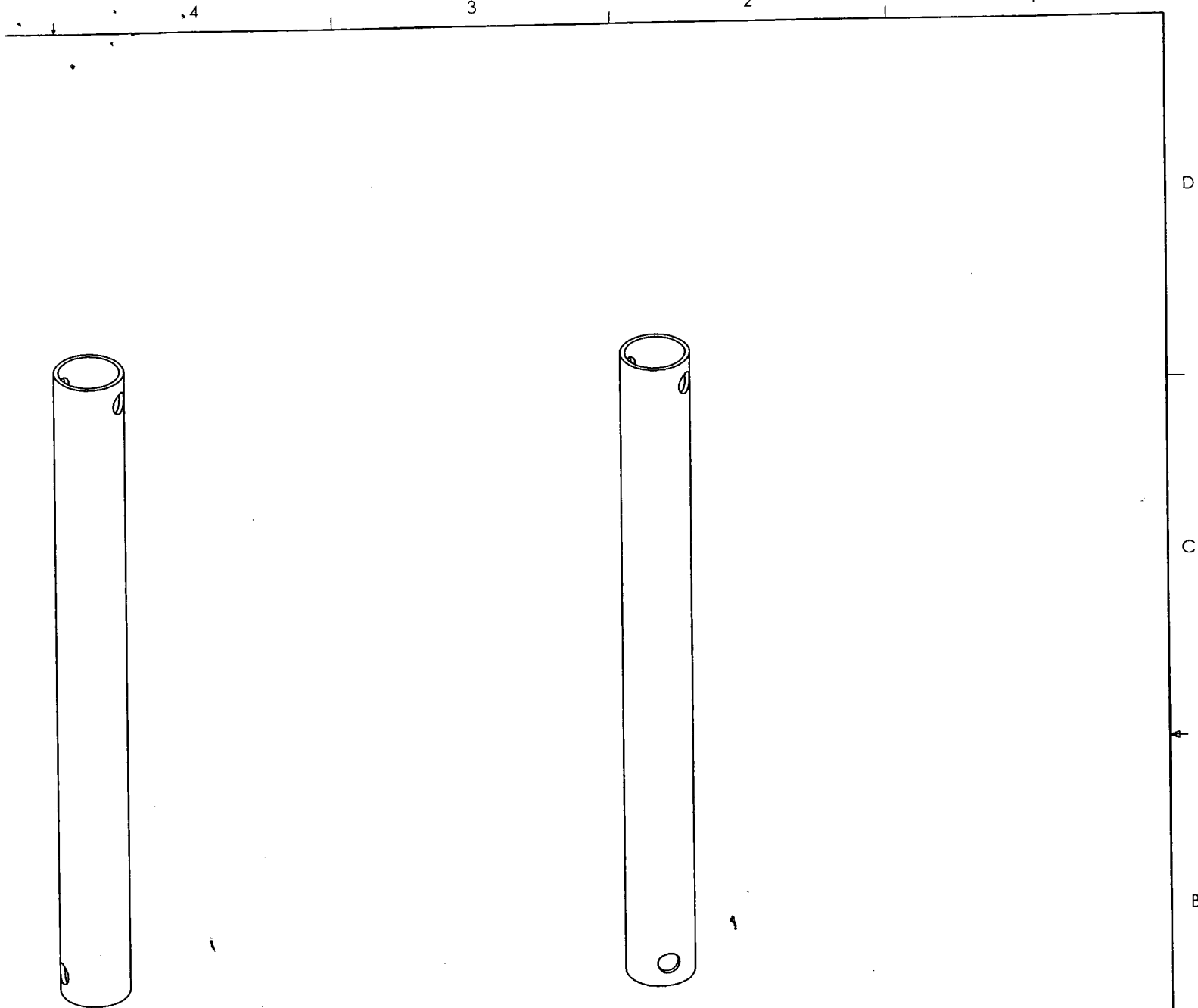
- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) ALUMINUM TUBING 1.00" OD X 0.065" WALL (REF. DART SPE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

8

7

6

5



ONT OUTBOARD LEG, LH

D3768-4 FRONT OUTBOARD LEG, RH **PROTOTYPE**

PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
08.04.23

PEC. M6061T6T1.00W.065)

| REV. | DESCRIPTION | | BY | DATE |
|------------|-------------|--|--|------|
| DESIGN | HS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWN | HS | | | |
| CHECKED | | DRAWING NO. | REV. A | |
| MFG. APPR. | | D3768 | SHEET 1 OF 4 | |
| APPROVED | | TITLE | SCALE | |
| DE APPR. | | FRONT LEG | NTS | |
| DATE | 08.03.26 | | COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

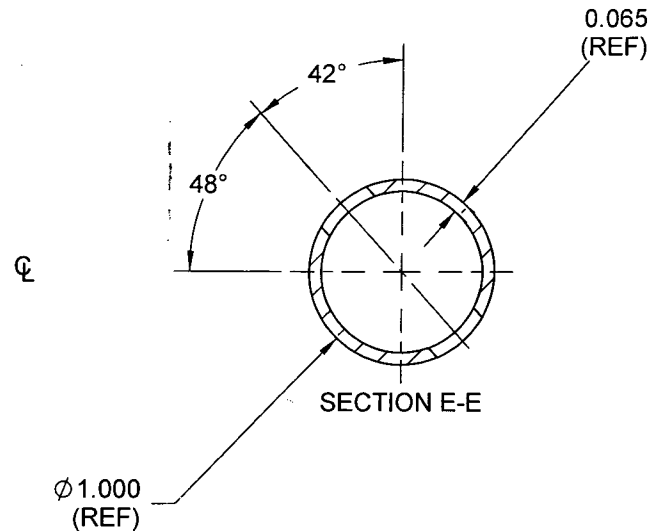
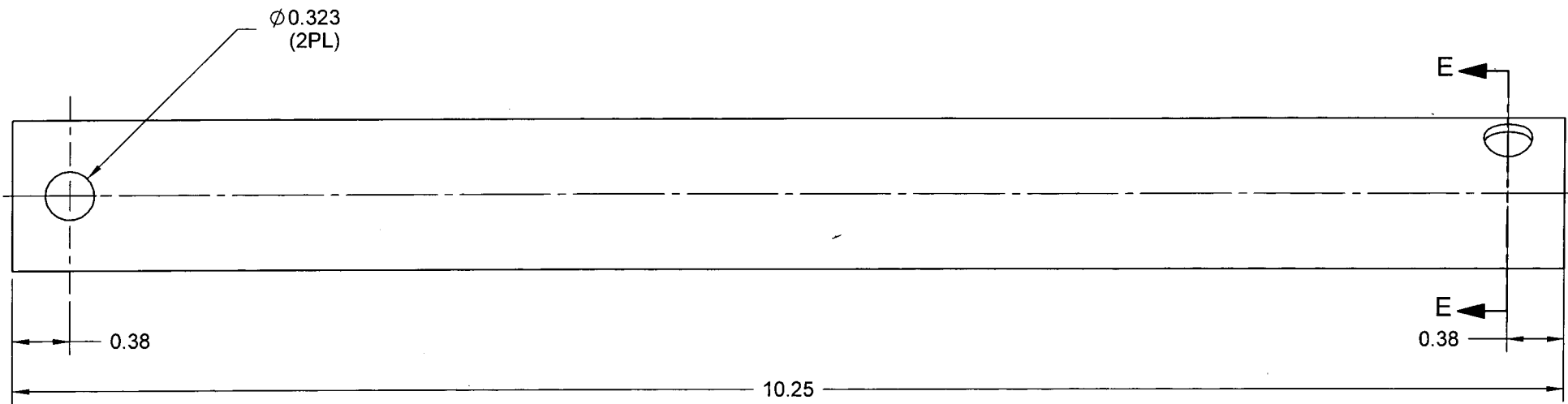
8 7 6 5 4 3 2 1

D

C

B

A



D3768-3 FRONT OUTBOARD LEG, LH

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
9/08.04.13

| | | | |
|------------|----------|--|--------------|
| DESIGN | HS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | HS | | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3768 | SHEET 3 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | FRONT LEG | 1:1 |
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8 7 6 5 4 3 2 1